

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029668**Date Inspected:** 23-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR**CWI Name:** Mike Inman**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Skyway Traveler Rail Replacement**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI) Dennis Combs was at the offsite fabrication facility of American Bridge Manufacturing (ABM) between times noted above in order to monitor Quality Control functions and the in process work being performed by ABM personnel. The following items were observed:

Skyway Traveler Rail Replacement - CCO # 24S0

The QAI periodically observed American Bridge Manufacture (ABM) welding personnel Mike Hebert and Ryan Whiteman performing base material preheating, preparation and welding operations. The welding operation was being performed by using the Flux Cored Arc Welding Gas Shielded (FCAW-G) process. Complete Joint Penetration (CJP) and fillet welding performed on the web to bottom flange connection on side A in the flat and horizontal position on traveler rail numbers 3030TR1, and 3034TR1.

This QAI observed QC Inspector monitoring the welding operation and verifying the electrical welding parameters according to Welding Procedure Specification (WPS) numbers ABM-SAS-07 and ABM-SAS-08, they appeared to be in general compliance.

OBG Cable Safety Railing Coating - CCO # 188

The QA Inspector periodically observed ABM coating personnel performing coating operations on the OBG Cable Safety Railing Posts with Interfine 979.

Summary of Conversations:

No relevant conversations.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
